

Work Order ID 74653

Wednesday, October 05, 2011 7:31:29 AM



ASAP

Page 1

Item ID: D3805-3

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-10-5

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	X B 11.10.06								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3805								
	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B11-10-6

(4)

B11-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 74653

Wednesday, October 05, 2011 7:31:30 AM

Page 3

Item ID: D3805-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Plate

Start Date: 10/5/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

Packaging

*Q 11-10-12**(x4)*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/10/12**MF**11-10-312*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 7:31:19 AM

Page 1

Work Order ID: 74653



Parent Item: D3805-3



Parent Item Name: Plate

Start Date: 10/5/2011

Required Date: 10/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
IPP Rev:B 08-07-29 new flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

223.3050

1.587

6.682105



B11-10-6

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

223.305

113062

0.005

118217

1

119032

222.3

119032

(4)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74653
Description: PLATE		Part Number: D3865-3
Inspection Dwg: D3865-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	$\pm .10$	4.04	X		V RBZ	
.125	$\pm .10$.130	X		V	
.938	$\pm .10$.938	X		V	
.875	$\pm .10$.873	X		V	
3.00	$\pm .030$	3.007	X		V	
5.420	$\pm .010$	5.422	X		V	
.250	$\pm .010$.254	X		V	
1.25	$\pm .020$	1.241	X		V	
Ø .188	$\pm .001$.192	X		V	
30.500	$\pm .10$	30.500	X		T RBZ	
7.000	$\pm .010$	7.000	X		T	
4.500	$\pm .010$	4.500	X		T	
5.320	$\pm .010$	5.320	X		T	
15.450	$\pm .010$	15.450	X		T	
38.175	$\pm .010$	38.175	X		T	
48.098	$\pm .010$	48.098	X		T	
49.27	$\pm .030$	49.27	X		T	
5.000	$\pm .010$	5.000	X		T	
.050	$\pm .010$.048	X		V	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-10-6	Date: 11/10/07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

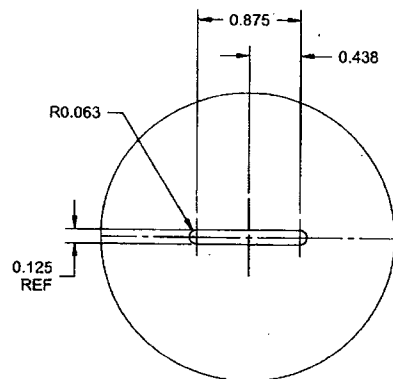
W/O:		WORK ORDER CHANGES					
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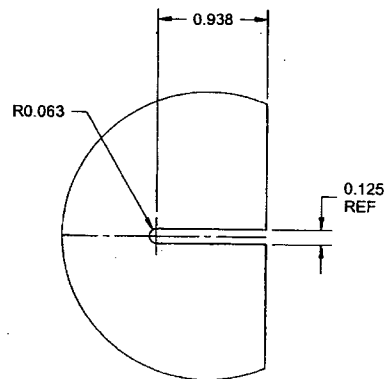
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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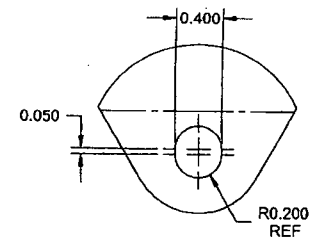
NOTE: Date & initial all entries



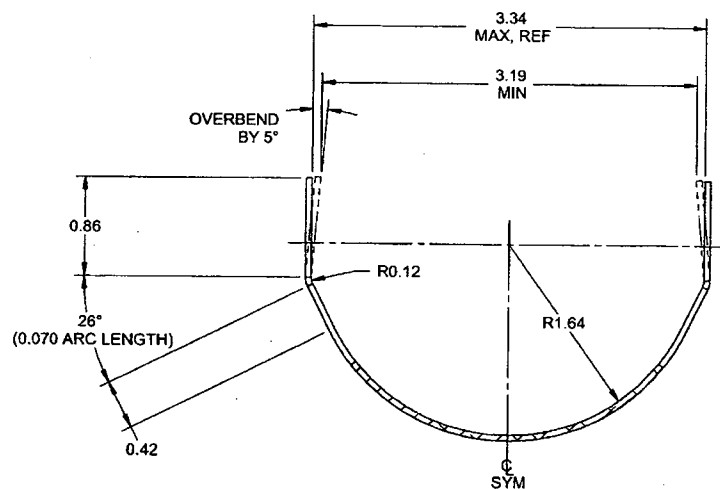
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

#74653

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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